

Date: Friday, 03/10/2008 7:37:25 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : IDLE STOP PLATE
 Job Number : 42433
 Estimate Number : 12629
 P.O. Number :
 This Issue : 03/10/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D2127251009
 First Issue : / / Type : MACHINED PARTS Drawing Number : D212-725-1 PG5
 Previous Run : 30184 Drawing Revision : B
 Material :
 Due Date : 10/10/2008 Qty: 10 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A New Issue 07-01-05 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0875X06000 6061-T6 Bar .875 x 6.00



Comment: Qty.: 0.7875 f(s)/Unit Total : 3.9375 f(s)

6061-T6 Bar .875" x 6.0"

Batch: M102838

H.A 08/10/17

(10)

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blank 8.900" long

H.A 08/10/17

(10)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA661 and Dwg D212-725-1

Deburr

H.A 08/10/21

(10)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A 08/10/21

(10)

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

H.A 08/10/22

(10)

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

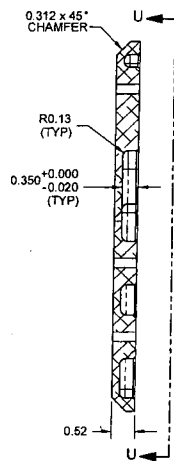
Chemical Conversion Coat as per QSI 005 4.1

H.A

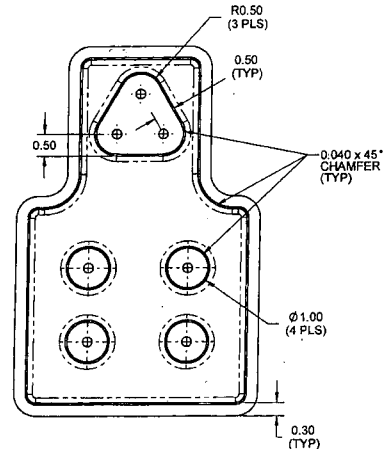
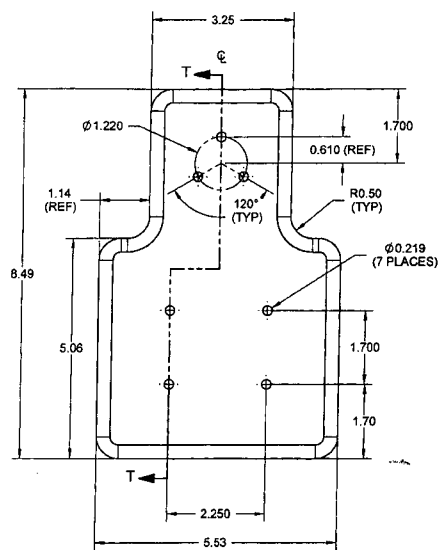
08-10-21

(10)

W1042433



SECTION T-T



VIEW U-U

D212-725-1-009 IDLE STOP MOUNT

- NOTES:
- 1) MATERIAL: 6061-T6 (QQ-A-250/8) OR (QQ-A-200/11) PLATE (REF. DART SPEC. M6061T6B)
 - 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME PER AIRCRAFT MAINTENANCE MANUAL
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: N/A

DESIGN	DC	DART AEROSPACE LTD	
DRAWN	RF	HAMMERSBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. D
MFG. APPR.	N/A	D212-725-1	SHEET 64 OF 67
APPROVED	#	TITLE	SCALE
DE APPR.	#	212S DETAIL PARTS	1:2
DATE	08.03.14	COPYRIGHT © 2006 BY DART AEROSPACE LTD. THIS DOCUMENT IS UNCLASSIFIED AND IS AVAILABLE FOR THE LIMITED CIRCULATION THAT IT IS AND TO BE USED FOR THE PURPOSES OF THE DART AEROSPACE LTD. ONLY. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM.	

RELEASED
(18-07-01)



DART AEROSPACE LTD		Work Order: 42433
Description: IDLE STOP PLATE		Part Number: D2127251009
Inspection Dwg: D212-725-1, Rev: D		Page 1 of 1

pg 64 of 67

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.312 x 45°	+/- .010	0.307 x 45°	✓			
R 0.130	+/- .030	R0.130	✓			
0.350	+0.000 / - 0.020	0.344	✓			
0.52	+/- .030	0.522	✓			
3.25	+/- .030	3.250	✓			
1.700	+/- .010	1.701	✓			
R0.50	+/- .030	R0.50	✓			
Ø 0.219	+0.005 / - 0.001	Ø 0.223	✓			
1.700	+/- .010	1.700	✓			
1.70	+/- .030	1.698	✓			
2.250	+/- .010	2.251	✓			
5.53	+/- .030	5.522	✓			
5.06	+/- .030	5.060	✓			
8.49	8.49 +/- .030	8.482	✓			
R0.50	+/- .030	R0.50	✓			
0.50	+/- .030	0.499	✓			
0.040 x 45°	+/- .010	0.039 x 45°	✓			
Ø 1.00	+/- .030	0.999	✓			
0.30	+/- .030	0.300	✓			

Measured by: Y.A.
Date: 08/10/21

Audited by: <i>Ind</i>
Date: 08/10/21

Prototype Approval:
Date:

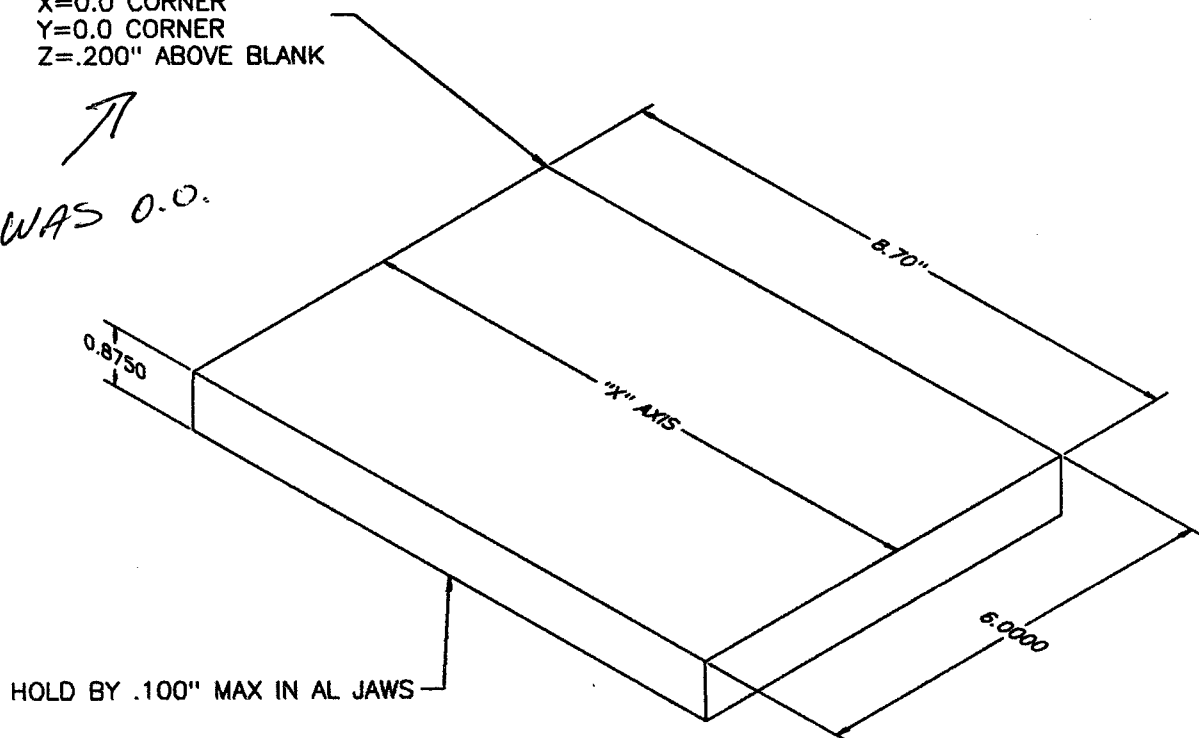
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

[Signature]

D212-725-1-009 IDLE STOP PLATE
1ST OPERATION
PROG #1000

G54:
X=0.0 CORNER
Y=0.0 CORNER
Z=.200" ABOVE BLANK

↑
WAS 0.0.



HOLD BY .100" MAX IN AL JAWS